

Date: Wednesday, 9/12/2007 12:13:22 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	NUT PLATE	
Job Number	34599				
Estimate Number	10316				
P.O. Number	N/A		Part Number	D2680041	
This Issue	9/12/2007	S.O. No. N/A	Drawing Number	D2680 REV B1	
Prsh Rev.	NC		Project Number	N/A	
First Issue	N/A		Drawing Revision	B1	
Previous Run	33061		Material	N/A	
Written By			Due Date	10/10/2007	
Checked & Approved By			Qty:	100 Um: Each	
Comment	Est: D 04/10/01 Added Steps 2-4, 7-8 KJ/JLM Est Rev:E Now on WaterJet 06-10-12 JLM est rev F QC5 after c'sink 07.07.05 EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
Comment: Qty.: 0.0138 sf(s)/Unit Total : 0.6878 sf(s)- 1010/1025/A21/6aA SHEET .063" thk Batch: m101034 HB 07-09-17		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2680 HB 07-09-17 Dwg Rev: B1 Prog Rev: B1		
2-Deburr if necessary SAD 07/09/21		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
HB 07-09-17		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK S A 09/18 140		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr SAD 07-09-23 2-C'sink as per Dwg D2680 SAD 07-09-01 139		
1 Mu. 07/09/25 (140)		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			
07/01/12	22	20 parts were found during water jetting to have a small cutout on the side. RL parts were too close together during water jetting and operator error.		Parts were attached			07/01/12	<input checked="" type="checkbox"/>	6
							07/01/12	07/01/12	07/01/12
07/10/12	6,0	One part scrap during the C'sink, Slip and didn't do the C'sink correctly initially		Scrap, destroy			07/10/12	<input checked="" type="checkbox"/>	07/10/12
							07/10/12	07/10/12	07/10/12

NOTE: Date & initial all entries

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Job Number: 34599		Part Number: D2680041
Job Number:		
Seq. #:	Machine Or Operation:	Description:
6.0	QC5	INSPECT WORK TO CURRENT STEP <i>QSP09</i> S 07/11/08 (X)139 Coated
7.0	POWDER COATING	POWDER COATING <i>M105914</i> 139X
Comment: INSPECT WORK TO CURRENT STEP		
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		<i>m/b</i> 07/11/08
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>Fd</i> 07/11/08 (139)
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
9.0	MS20426AD33	Rivet
Comment: Qty.: 2.0000 Each(s)/Unit Total : 400.0000 Each(s) Pick: 278		<i>M1563</i> AS 07/11/08
10.0	MS21069L4	Nutplate
Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Pick: 139		<i>M18536</i> K 07/11/08
11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 <i>MS09/11/08 (139)</i>
Comment: SMALL & MEDIUM FAB RESOURCE 1 Install Nut Plate as per Dwg D2680		
12.0	QC5	INSPECT WORK TO CURRENT STEP <i>QSP09</i> 09/11/08 (X)139 Coated
Comment: INSPECT WORK TO CURRENT STEP		
13.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>STL40</i> AS 07/11/08 J
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/11/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Job Number: 34599		Part Number: D2680041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
14.0	QC21	FINAL INSPECTION/W/O RELEASE
		 (139)
Comment: FINAL INSPECTION/W/O RELEASE		<i>P.D. 11/12</i>
Job Completion		 <i>W.B.I.R.</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34599
Description: Nut Plate	Part Number:	D2680-1
Inspection Dwg: D2680 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

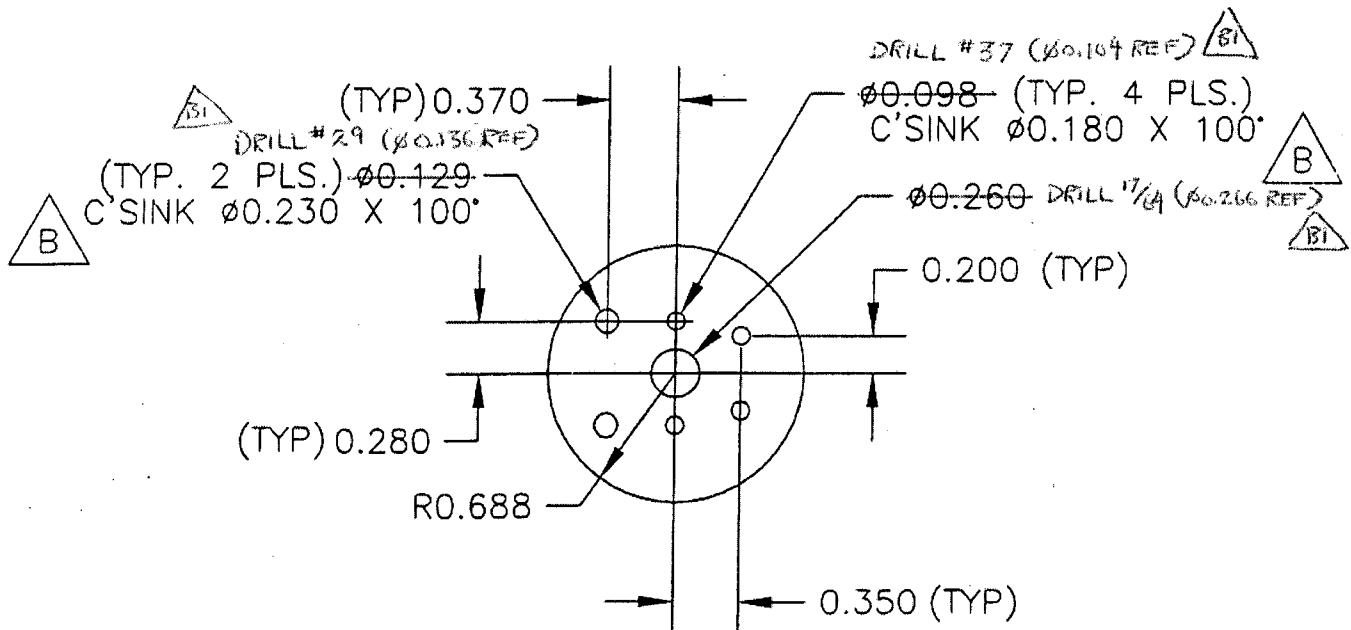
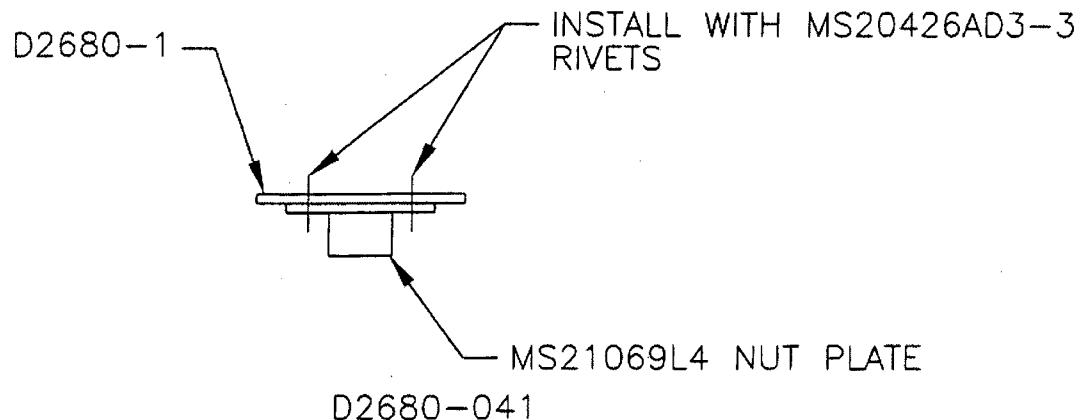
X First Article Prototype

Measured by:	<u>HB</u>	Audited by:	<u>EP</u>	Prototype Approval:	N/A
Date:	01-09-17	Date:	01/09/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	P/O D2680-041	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>

DART

DESIGN <i>#</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2680
DATE 98.12.14		REV. B SHEET 1 OF 1
		TITLE SCALE 1:1
A	97.09.15	NEW ISSUE
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)
I.B.I.	04.11.04	CHANGE HOLES & FINISH

RELEASED
98.12.14 DS

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.063 THICK (16 GAUGE)

CAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

(B1) POWDER COAT WHITE (4.75 S.I.) PER DART QSI 005 4.3

D2680-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *3459*